

Work Order ID 61404



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August 24, 2010 9:01:10 AM

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 8/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 10/8/24 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

8/10/09/21

HJ BG 10-8-25

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/8/24 SP (42)

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/09/21

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-011 Location: <u>B</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Cup/g/23 (g)

10/09/24
MF
10-9-23

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NOTE: Date & initial all entries

Picklist Print

August 24, 2010 9:01:09 AM

Page 1

Work Order ID: 61404

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from
Step 1, 3 KJ/DS
IPP Rev: D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S 41 D3121-141 Bracket Assembly		Manufactured	No			100	Each	12.0000	3	12		10/8/24	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				12					
				60291				12					
S 41 D3121-143 Bracket Assembly		Manufactured	No			110	Each	3.0000	1	4		10/8/31	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				3					
				58767				3					
S 41 D3183-043 Bracket Assembly		Manufactured	No			110	Each	2.0000	1	4		10/8/31	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST236				2					
				54759				2					
S 41 D3137-043 Bracket Assembly		Manufactured	No			110	Each	5.0000	1	4		10/8/24	sf
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				5					
				59916				5					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61404



Parent Item: D412-698-011



Parent Item Name: Cabin Door Roller, LH

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

D3199-1 Manufactured No

110 Each

86.0000

9

36



10/6/24 sf

Bracket

Location

Loc Qty

Loc Code

ST236A

86

60066

53

60498

33

36

D3202-1 Manufactured No

110 Each

3.0000

1

4



10/8/24 sf

Cover

Location

Loc Qty

Loc Code

ST241A

3

50134

3

3

361694 (1X) 10/9/21 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

REFERENCE ONLY

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01